

Date: Wednesday, 8/8/2007 1:38:03 PM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE ASSEMBLY
Job Number	: 33851A		
Estimate Number	: 10309		
P.O. Number	:	Part Number	: D206642541
This Issue	: 8/8/2007 S.O. No. :	Drawing Number	: D3274 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LANDING GEAR	Drawing Revision	: D
Previous Run	: 33850A	Material	:
Written By	: <u>Am 07-08-08</u>	Due Date	: 8/15/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

2.0	D26001190	Extrusion Round 3" 206
-----	-----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-190 3" OD Tube

B24841

Am 07-08-08

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

Am 07-08-08



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Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



pm 07-08-08



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



DP 7-8-9



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

QC5

INSPECT WORK TO CURRENT STEP



DP 7-8-9



Comment: INSPECT WORK TO CURRENT STEP

7.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B 33224

7-8-24

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

pm 07-08-09

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

pm 07-08-09

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

pm 07-08-09

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

M 104989

Sikaflex expire date:

8-1-1

Start: *7-8-24*

Time: *12:30*

Finish: *7-8-27*

Time: *10:20*

(Adhere for 12 hours)

7-8-24

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/07

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



PRC

LAST
Page

Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

✓ 7-8-07

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap

13.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649 Crossbolt spacer

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

3-Grind welds flush to Fwd cap on top surface only.

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D3415041	Nut Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	

21.0	CCR264SS33	Cherry Rivet
------	------------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	

22.0	CR3212403	Cherry Rivet
------	-----------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	

23.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch: _____

24.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.
A/RN/ALPS-3 _____

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a
A/R Sikaflex-291 _____
Sikaflex expire date: _____

Date: Wednesday, 8/8/2007 1:38:04 PM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

26.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch: _____

27.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

28.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

29.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

30.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: _____

31.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

Process Sheet

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Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D353623

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

33.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

34.0

D353639

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: _____

35.0

D35371

WEARPAD



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: _____

36.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

37.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer

38.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 NAS1515H3L

Washer

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Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring

40.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt

41.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer

42.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

43.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

Sikaflex expire date:

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch:

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 33851A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expire date:

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 070921



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 **[Signature]**

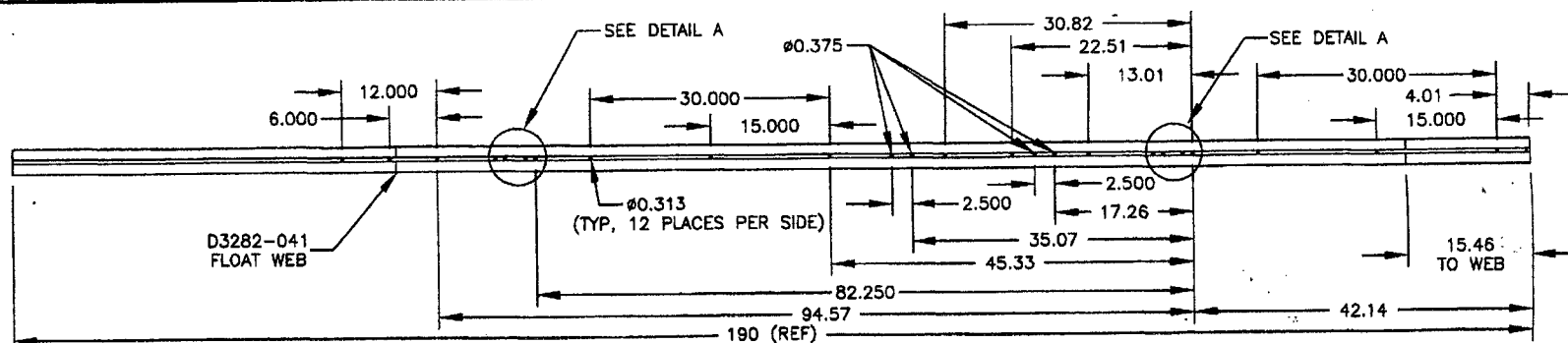
Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

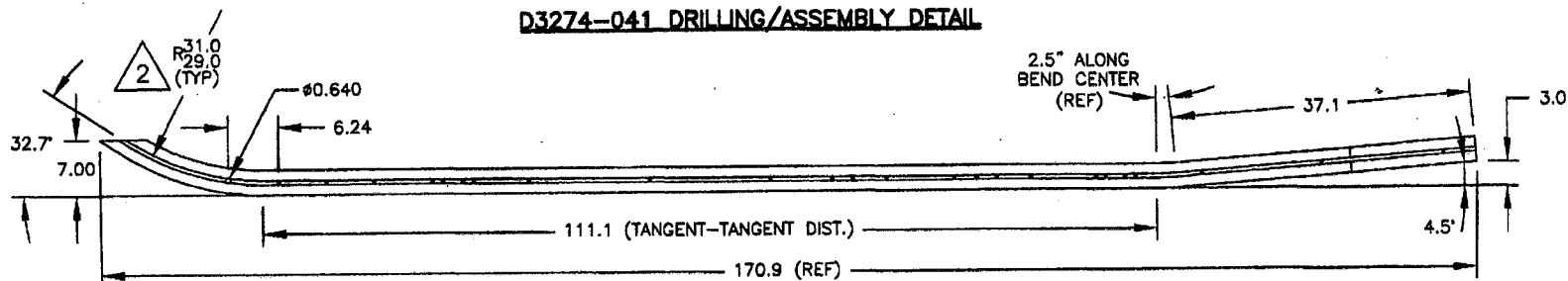
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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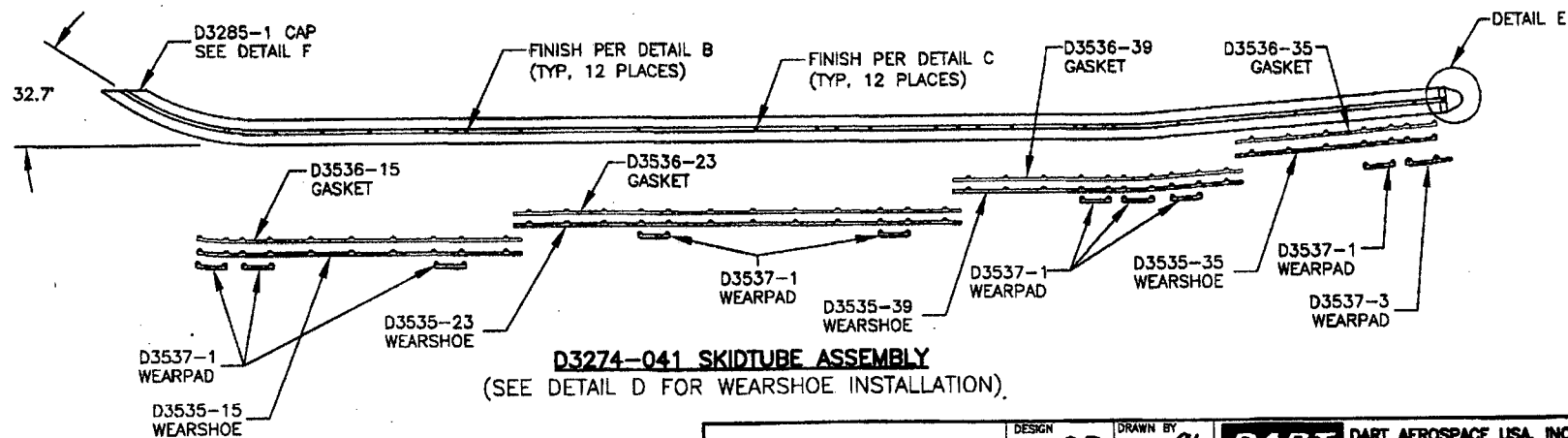
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL

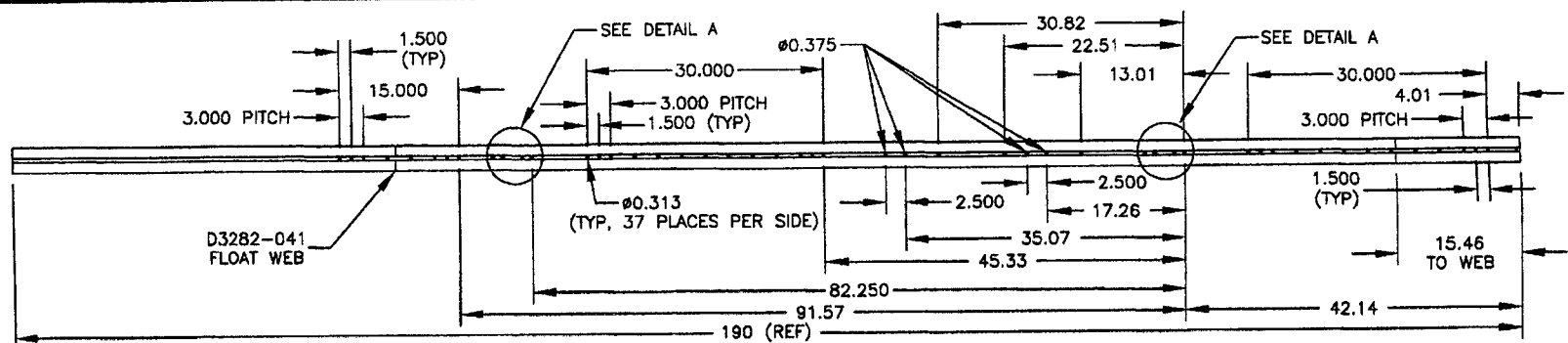


D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

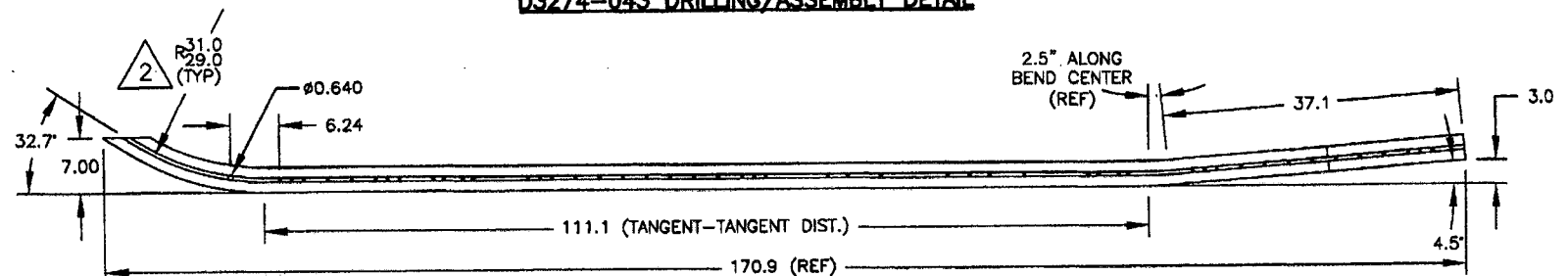
RELEASED

07.01.12

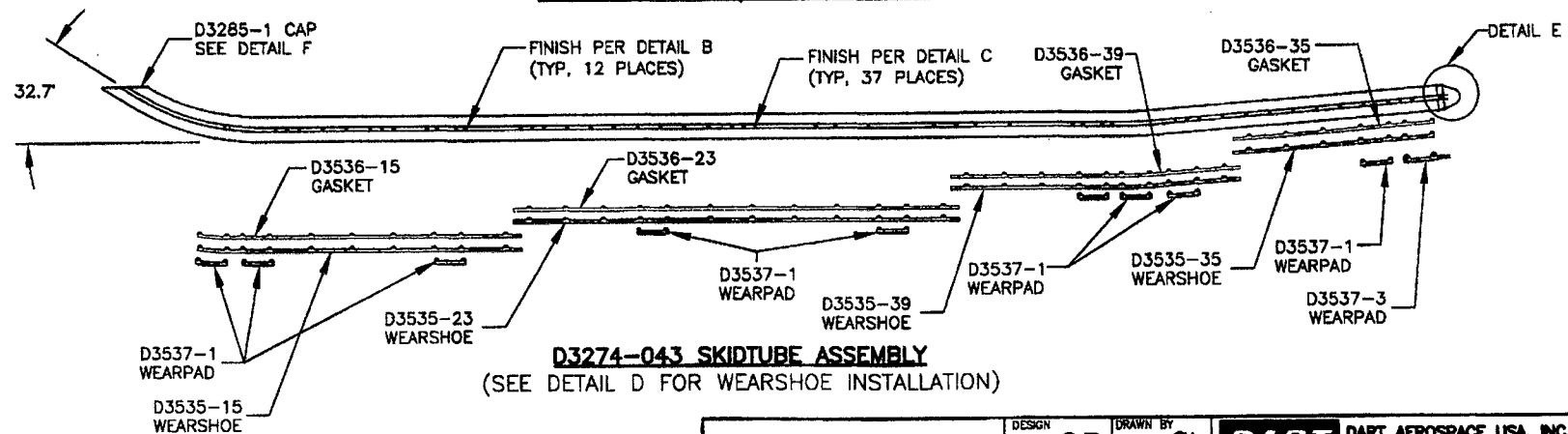
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DATE 06.12.19		CHECKED #	APPROVED #	TITLE SKIDTUBE ASSEMBLY SCALE 1:15	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

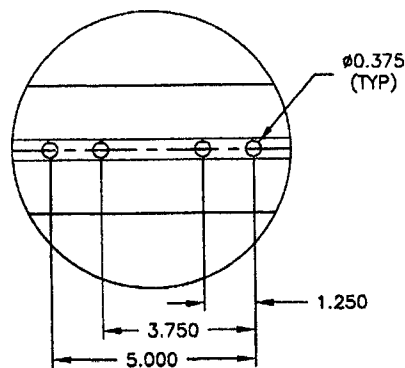
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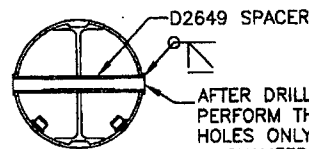
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC.	REV. D
CHECKED	H	APPROVED	H	DRAWING NO.	SHEET 3 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

DETAIL A: DRILL DETAIL

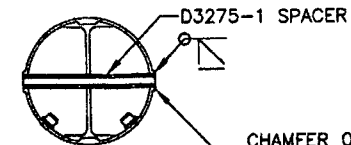


DETAIL B FOR Ø0.375 HOLES ONLY



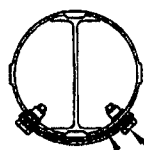
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D

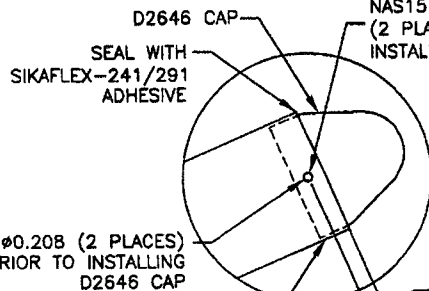


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS151SH3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

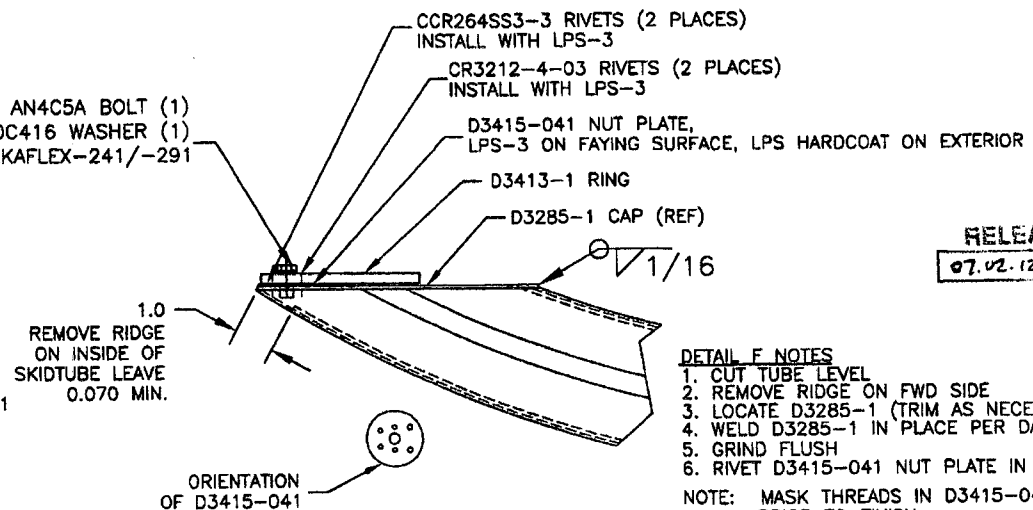


Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

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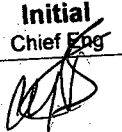
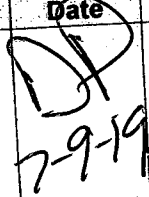
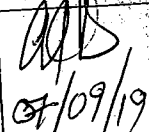
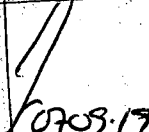
DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng			
07-19	10.0	Employee placed the tube in the bundle in the opposite direction. RC: human error.	 07/09/19	SCUARD: destroyed.	 7-9-19	 07/09/19	 07-09-19

NOTE: Date & initial all entries